



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PC250-300A
Job Sheet 200687



Part No: PC250-300A

Job Qty: 3 pcs

Part Name: Load Beam Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/16/19

Job Tracking No:

Due Date: 11/1/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG PC250-300A REV:1 IPP REV A 18.02.27 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	3 pcs	11/1/19		0.00	0.20	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		AP 2019-11-26
							Small Fab - 8		
105	Conventional Mill - 1 - B4B	3 pcs	11/1/19		0.00	1.00	Conventional Mill - 1 - B4B		AP 19/11/26
							Conventional Mill - 2 - B4B		
110	QC 2	3 pcs	11/1/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S234926



Part: PC250-300A

Job No: 200687

Serial No/Batch: S234926

Revision: 1

Inspector:

Plex 9/16/19 2:34 PM Dart.Renwick.Jennifer

				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	11/19/11/26
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
115 QC 8	3 pcs	11/1/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	11/19/11/26
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
120 Small Fab - 2 - B4B	3 pcs	11/1/19	0.00 0.75	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	AP 2019-11-26
				Small Fab - 8 - B4B	
125 QC 5	3 pcs	11/1/19	0.00 0.00	QC 5 - 10	

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			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	NOV 26 2019
			QC 5 - 9	DAS 68 9-89
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
130	Outsource - 15 - Nickel Plate	3 pcs	11/1/19	GRO002-VC 10
				2019-11-26
140	Packaging 2-1 - Receive - B4B	3 pcs	11/1/19	0.00 0.00
				Packaging 2 - 1 - B4B
				Packaging 2 - 2 - B4B
				Packaging 2 - 3 - B4B
				Packaging 2 - 5 - B4B
				Packaging 2 - 4 - B4B
				Packaging 2 - 6 - B4B
				Packaging 2 - 7 - B4B
				Packaging 2 - 8 - B4B
				Packaging 2 - 9 - B4B
				Packaging 2 - 10 - B4B
				Packaging 2 - 11 - B4B
				Packaging 2 - 12 - B4B
				Packaging 2 - 13 - B4B
				Packaging 2 - 14 - B4B
				Packaging 2 - 15 - B4B
				Packaging 2 - 16 - B4B
				Packaging 2 - 17 - B4B
				Packaging 2 - 18 - B4B
				Packaging 2 - 19 - B4B
				Packaging 2 - 20 - B4B
				Packaging 2 - 21 - B4B
				Packaging 2 - 22 - B4B
				Packaging 2 - 23 - B4B
				Packaging 2 - 24 - B4B
				Packaging 2 - 25 - B4B
				Packaging 2 - 26 - B4B
				Packaging 2 - 27 - B4B
				Packaging 2 - 28 - B4B
				Packaging 2 - 29 - B4B
				Packaging 2 - 30 - B4B
				Packaging 2 - 31 - B4B
				Packaging 2 - 32 - B4B
				Packaging 2 - 33 - B4B
				Packaging 2 - 34 - B4B
				Packaging 2 - 35 - B4B

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150 QC 6	3 pcs	11/1/19	0.00 0.00	Packaging 2 - 36 - B4B	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	DAS 40 DEC 1 1 2019
160 Packaging 3-1 - Stock - B4B	3 pcs	11/1/19	0.00 0.00	QC 6 - 81	9-89
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS 28 9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - FG	3 pcs	11/1/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	19-12-13

Part Op 100 - (Small Fab) Pick

Descriptions: 105 - MILL HOLES TO PRESS FIT TRUNNION

110 - (QC2- Inspect parts off machine FAI/FAIB)

115 - (QC8- Inspect parts - second check)

120 - Assemble as per drawing

130 - (Outside Processing - Nickel Plate) -Issue P/O; 45215 -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required

140 - (Receive & Inspect for Damage & Mat'l Certs)

150 - (QC6- All purchased or subcontracted products)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
PC250-300	Load Beam	3 pcs (1 ea)	100-Small Fab - 1	S226724
PC250-310	Trunnion	3 pcs (1 ea)	100-Small Fab - 1	S194959

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	PC250-300	3	0	0
	PC250-310	3	3	0

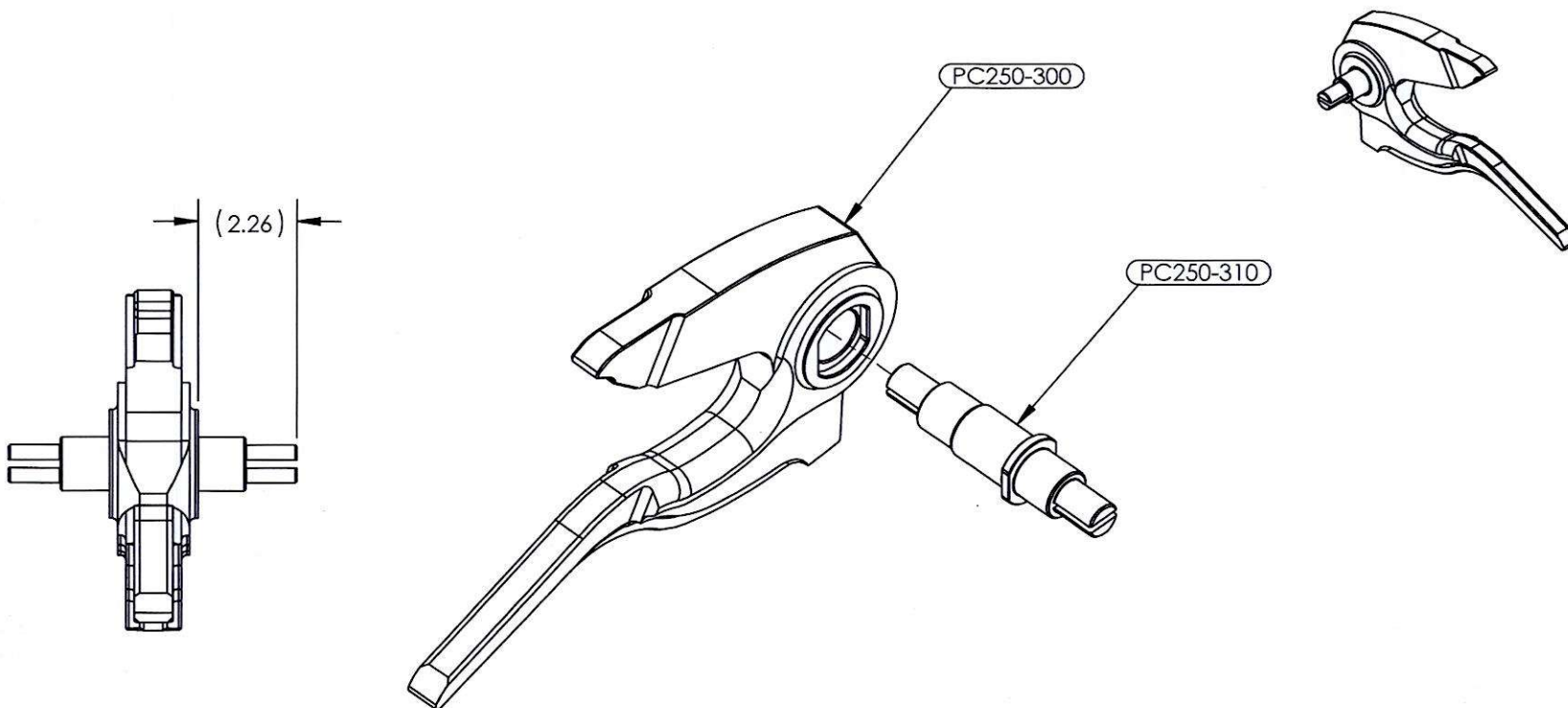
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
		AS DRAWN BY APICAL.	6/12/2013	CFS	
1	14-0128	CH'D TITLE BLOCK WAS RED BARN IS DART. CORRECTED TITLE & DWG No ON ALL SHEETS. PC250-300 ADDED MACHINE ENGRAVE NOTE. PC250-310 ADDED BAG & LABEL NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/14/2014	DPD	RW



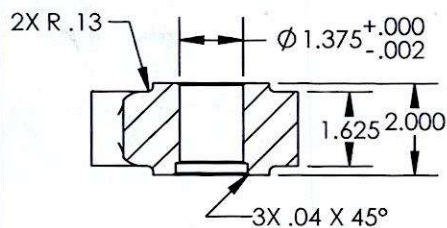
NOTE:
1. NICKEL PLATE .0009-.0011, BAKE AFTER PLATING.

DART AEROSPACE	
TITLE LOAD BEAM ASSEMBLY	
DWG NO. PC250-300A	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: APICAL APPROVED <i>D Weid</i> HEAT TREAT FINISH NICKEL PLATE SPEC SEE NOTE 1 USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 5/19/2004 SHEET 1 OF 3

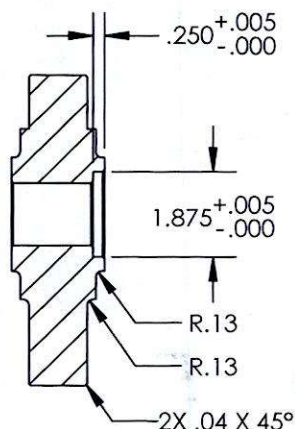
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			PC250-300	1	LOAD BEAM	4140	8 X 14-1/2	2
			PC250-310	1	TRUNNION	4140	Ø1-7/8 X 6-5/8	3

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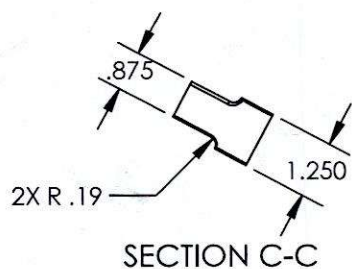
REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1	14-0128	PC250-300 ADDED MACHINE ENGRAVE NOTE.			8/14/2014	DPD	RW



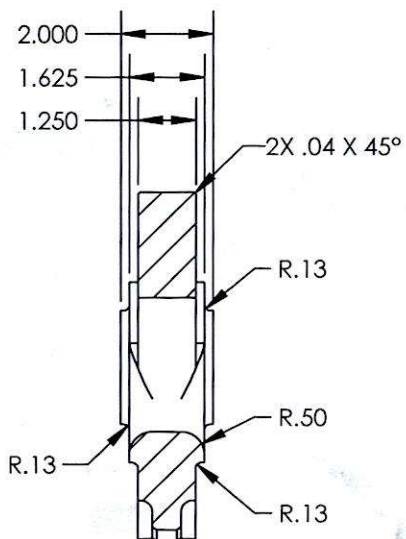
SECTION A-A



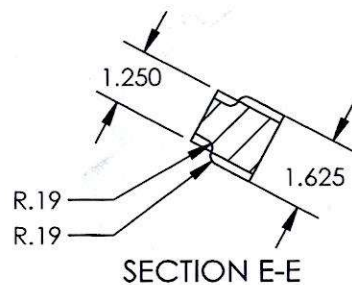
SECTION B-B



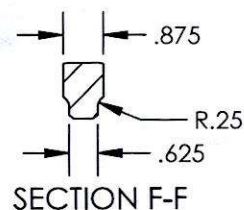
SECTION C-C



SECTION D-D



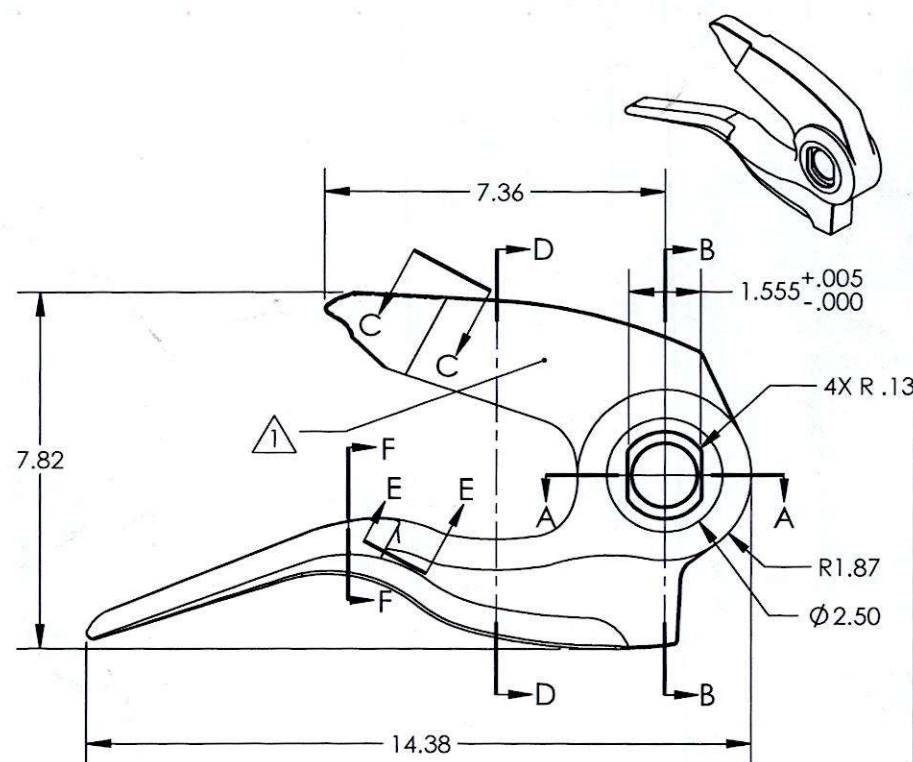
SECTION E-E



SECTION F-F

PC250-300

LOAD BEAM

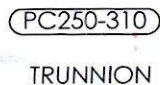


NOTE:

1 MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE LOAD BEAM ASSEMBLY	
DWG NO. PC250-300A	REV 1
MATL 4140	DRAWN BY: APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± .5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 5/19/2004
SHEET 2 OF 3	

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0128	PC250-310 ADDED BAG & LABEL NOTE.	8/14/2014	DPD	RW



			
TITLE			
LOAD BEAM ASSEMBLY			
DWG NO.			REV
PC250-300A			1
MAT'L 4140		DRAWN BY: APICAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D. Weel</i>	
.XXX ± .005	FRACTIONS ± 1/8	HEAT TREAT HRC 44-46	
.XX ± .01	ANGLES ± 5°	FINISH SEE SHEET 1, NOTE 1	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE 1:2	DATE 5/19/2004	SHEET 3 OF 3	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045215



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045215

PO Date: 11/26/19

Due Date: 12/4/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-27

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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PURCHASE ORDER

POHB045215



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201988	20NR-84B	20NR-84B Rev 2	Spacer Dual Cage 4, 5/8" hole NICKEL PLATTING -Issue P/O; -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; 1045 -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	12/4/19	6 pcs	0 pcs	6 pcs	\$15.50/pcs	\$93.00

X 6

DEC 11 2019

DP



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045215



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	200687	PC250-300A	PC250-300A Rev 1	Load Beam Assembly (Outside Processing - Nickel Plate) - Issue P/O -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	12/4/19	3 pcs	0 pcs	3 pcs	\$65.20/pcs	\$195.60

X3

DEC 11 2019

DP

Grand Total: \$371.70

Guerin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045215



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/27/19 3:23 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(024465-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

024465 - 2

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
10-Dec-2019		SPARTAKOS BOUNTOURIS		POHB045215				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	20NR-84B Rev.2	20NR-84B E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290 OR ASTM B733 TYPE - 4 / 5, SCO - SC4 OR MIL-C-26074 CLASS 1 / 2 0.0004 " - 0.0006 " THICKNESS BAKE AFTER PLATING	E-NICKEL STEEL CH	6	6	0	0	0
3	PC250-300A Rev.1	PC250-300A E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290 OR ASTM B733 TYPE - 4 / 5, SCO - SC4 OR MIL-C-26074 CLASS 1 / 2 0.0009 " - 0.0011 " THICKNESS BAKE AFTER PLATING	E-NICKEL-500 CH	3	3	0	0	0
4	BAKING CHARGES Rev.	BAKING CHARGES BAKING, HYDROGEN EMBRITTLEMENT RELIEF	BAKE MIN-CHG	9	9	0	0	0

RECEIVED
 DEC 11 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.